

SPLIT

Date: Monday, 2/5/2007 8:07:00 AM  
User: Kim Johnston

Process Sheet

SPLIT - 1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number	: 30593 -1	Part Number	: D2572
Estimate Number	: 10531	Drawing Number	: D2572 REV E
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 2/5/2007	Drawing Revision	: E
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 2/15/2007
Previous Run	: 30213	Qty:	12 Um: Each
Written By	: <u>JA 02.02.05</u>		
Checked & Approved By	: <u>JA 02.02.05</u>		
Comment	: Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1 0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 12.0000 Each(s)  
7075-T7351 8.25X5.0X2.5  
Make from D6101-005 billet for D2572  
Ensure that grain is along 5.00" length  
Batch No: 25352

SG 07.04.11

9

2 0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1  
Program Batch No. B30593 Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets  
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets  
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets  
4-Deburr and remove all machining marks  
5-Tumble to remove shap edges.

SG 07.04.11 / 16 9

3 0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE  
Machine keyway as per dwg D2571 & D2572

SG 07.04.11 / 16 9

4 0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SG 07.04.11 / 16 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/17

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 30593

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

JL 07/04/16

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fel

07/04/16 (9)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Fel/

07-04-16 (9)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

07/04/16 (7)

7

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

07/04/16 (7)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/04/17 (7)

Job Completion



il 07-04-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	30593
<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b>	D2572
<b>Inspection Dwg:</b> D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.746	1.749	1.748		
C	3.495	3.505		3.500	3.499	3.500	3.500		
D	1.745	1.755		1.750	1.746	1.749	1.748		
E	7.990	8.010		8.002	8.004	8.002	8.001		
F	0.490	0.510		0.503	0.498	0.494	0.492		
G	0.257	0.262	DT8683	0.260	0.259	0.259	0.257		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.502	0.498	0.495	0.500		
J	1.174	1.184		1.179	1.177	1.179	1.178		
K	0.558	0.578		0.571	0.562	0.566	0.564		
L	1.174	1.184		1.179	1.177	1.179	1.178		
M	1.490	1.500		1.495	1.491	1.491	1.493		
N	2.495	2.505		2.500	2.500	2.500	2.498		
O	3.869	3.879		3.871	3.872	3.872	3.873		
P	0.115	0.135		0.132	0.132	0.134	0.134		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.254	0.256	0.256		
S	0.115	0.135		0.132	0.124	0.130	0.131		
T	0.178	0.198		0.187	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.245	0.241	0.233	0.236		
W	0.115	0.135		0.130	0.134	0.130	0.130		
X	0.307	0.312		0.311	0.311	0.311	0.311		
Y	0.760	0.765		0.762	0.765	0.765	0.765		
Z	0.352	0.372		0.367	0.367	0.365	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.632	0.625	0.628	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.251	0.245	0.248		
AE	1.375	1.395		1.387	1.386	1.388	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.250	0.260	0.260	0.266		
AH	0.240	0.260		0.253	0.258	0.247	0.250		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: <u>BC</u>	Audited by: <u>JA</u>
Date: <u>07.04.11</u>	Date: <u>07.07.13</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





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<b>Description:</b> Saddle, Fwd Inboard		<b>Part Number:</b>	D2572
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B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.001		
F	0.490	0.510		0.500	0.500	0.500	0.503		
G	0.257	0.262	DT8683	0.259	0.259	0.259	0.259		
H	0.375	0.380	DT8684	0.377	0.377	0.377	0.377		
I	0.490	0.510		0.495	0.496	0.492	0.496		
J	1.174	1.184		1.177	1.178	1.178	1.178		
K	0.558	0.578		0.567	0.567	0.568	0.567		
L	1.174	1.184		1.177	1.178	1.178	1.178		
M	1.490	1.500		1.494	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.873	3.871	3.871	3.871		
P	0.115	0.135		0.134	0.131	0.131	0.131		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.255	0.254	0.254	0.254		
S	0.115	0.135		0.135	0.135	0.132	0.135		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.231	0.244	0.238	0.241		
W	0.115	0.135		0.125	0.135	0.135	0.135		
X	0.307	0.312		0.311	0.309	0.309	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.360	0.366	0.366		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.626	0.625	0.625		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.247	0.250	0.248	0.248		
AE	1.375	1.395		1.390	1.384	1.383	1.388		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.255	0.249	0.255		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by: En  
Date: 07/01/13

Audited by: J.L  
Date: 07/04/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	





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E	7.990	8.010		8.001					
F	0.490	0.510		0.501					
G	0.257	0.262	DT8683	0.259					
H	0.375	0.380	DT8684	0.376					
I	0.490	0.510		0.500					
J	1.174	1.184		1.178					
K	0.558	0.578		0.568					
L	1.174	1.184		1.178					
M	1.490	1.500		1.495					
N	2.495	2.505		2.500					
O	3.869	3.879		3.871					
P	0.115	0.135		0.127					
Q	0.115	0.135		0.135					
R	0.240	0.260		0.252					
S	0.115	0.135		0.134					
T	0.178	0.198		0.188					
U	2.940	2.980		2.960					
V	0.230	0.250		0.238					
W	0.115	0.135		0.129					
X	0.307	0.312		0.310					
Y	0.760	0.765		0.765					
Z	0.352	0.372		0.360					
AA	0.470	0.530		0.500					
AB	0.615	0.635		0.627					
AC	0.053	0.073		0.063					
AD	0.240	0.260		0.249					
AE	1.375	1.395		1.378					
AF	0.115	0.135		0.135					
AG	0.240	0.280		0.266					
AH	0.240	0.260		0.251					
AI	2.000	2.020		2.000					
AJ	0.023	0.043		0.033					
Accept/Reject									

Measured by:	and
Date:	07/04/14

Audited by:	J.L
Date:	07/04/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



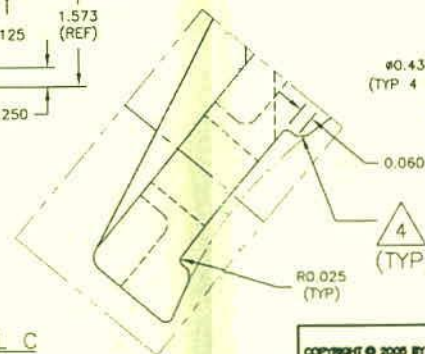
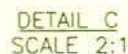





05.12.06 ~~11~~



MATERIAL: 7075-17351 (QQ-A-250/12)  
(REF DART SPEC. D8132-003)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER  
DART QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |  |
|---|--|
| 1 | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
| 2 | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)      |
| 3 | CHAMFER 0.063" x 45° ALL AROUND                                  |
| 4 | CHAMFER 0.033" x 45° (SEE DETAIL C)                              |



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCRP. DEQ 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS		DRAWN BY PH
CHECKED 		APPROVED 
DATE 05.07.13		TITLE INNER FWD SADDLE
		 <b>DART AEROSPACE LTD.</b> HANBURY, CHICAGO, CANADA
		REV. _____ SHEET 3 OF 3 SCALE _____

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NO. 30593

